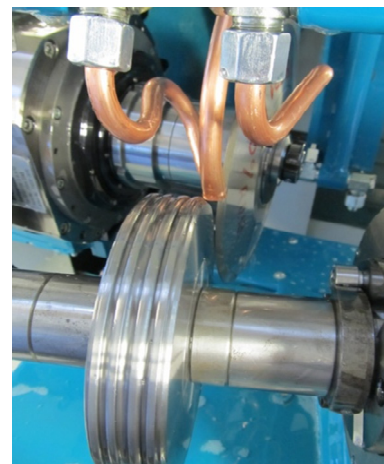
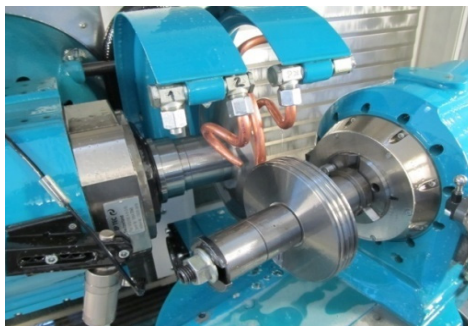


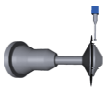





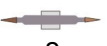


From-Roll Ø130 L 25

A20-900

The carbide formroll is preshaped with a roughing process of type plunge-rotate-grinding. A pregrinding and 2 finishing processes were applied of type cylindrical profile-grinding with 2 different wheels at a tool-rpm of 125 n/Min.



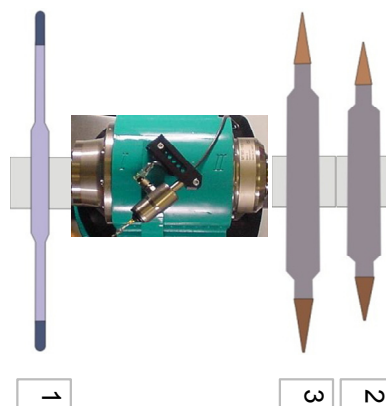
1. Cycletime for Production

Workpiece:	Cylindrical blank of Ø130, B=25 mm, Bore 35 mm				
Material	CARBIDE				
Operations					
Feed [mm/Min]	2000	6	1	1	1
Power [kW]		2	1	1	1
Cutting speed [m/s]		20	22	35	35
Used wheels					
Grinding time [s]	12	1150	4324	4324	2164
Total cycle time	199 Min 34				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø200 D64 C150 R1
2	14EE1 Ø150 D76V20° R02
3	14EE1 Ø200 D46V20° R01



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : SIRIUS HPM

Control: Fanuc 31i

Accessories:

Responsible engineer: OP, 13.6.14

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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